

Work Order ID 53455

November 6, 2009 8:20:26 AM



Page 1

Item ID: D3566-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Gasket

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date:

09-11-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3566	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

IB 9-11-16

(36)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 9-11-16

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) 509/11/16

counter

(36) /

Work Order ID 53455

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Page 2

Item ID: D3566-1

Revision ID: C

Item Name: Gasket

Start Date: 05/11/2009 Start Qty: 12.00

Required Date: 13/11/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							9/11/10
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							09/11/17 mf 09-11-17

Picklist Print

November 6, 2009 8:20:30 AM

Page 1

Work Order ID: 53455



Parent Item: D3566-1RevC



Parent Item Name: Gasket

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	1,020.995	11.5074	35.		
NEOPRENE SHEET 0.063											13 9-11-16	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	1020.9955	
112508	61.6034	
112662	320.2821	
112866	239.11	
113058	400	

112866

35

DART AEROSPACE LTD		Work Order:	53455
Description: Gasket		Part Number:	D3566-1
Inspection Dwg: D3566 Rev: C		Page 1 of 1	

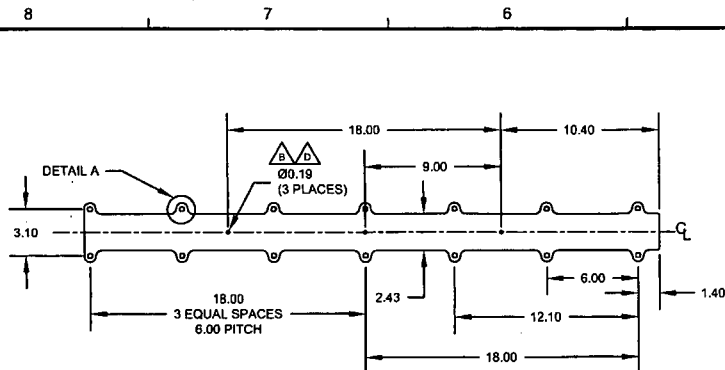
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

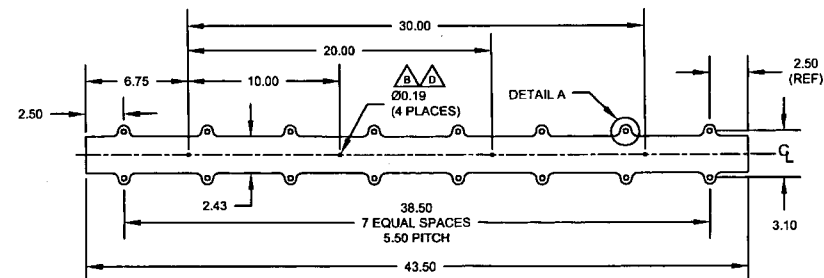
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.099	✓			
18.00	+/-0.030	18.00	✓			
12.10	+/-0.030	12.10	✓			
2.43	+/-0.030	2.435	✓			
6.00	+/-0.030	6.000	✓			
1.40	+/-0.030	1.401	✓			
0.30	+/-0.030	.300	✓			
0.30	+/-0.030	.303	✓			
0.063	+/-0.010	.058	✓			
Ø0.188	+0.005/-0.001	.188	✓			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-16	Date:	02/11/17	Date:	N/A

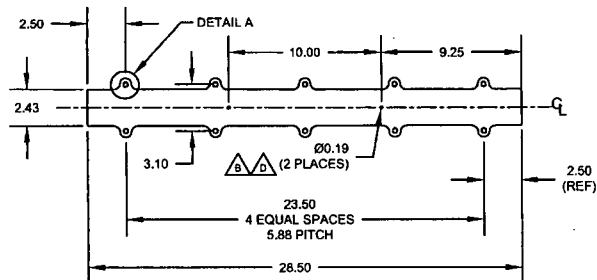
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD	E



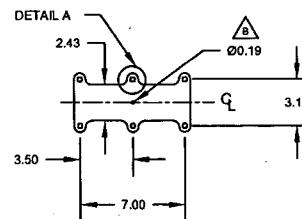
D3566-1 GASKET



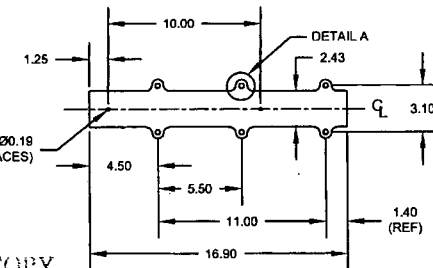
D3566-5 GASKET



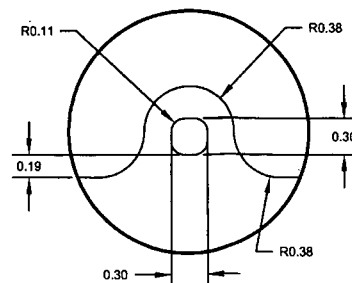
D3566-7 GASKET



D3566-13 GASKET



D3566-15 GASKET



**DETAIL A
SCALE 1:1**

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53455
P109-11-5

RELEASED

07.08.04

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT ϕ

C	UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	SCALE	
DATE	07.08.21	1:	
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